

Date: Wednesday, 09/07/2008 1:26:50 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B LOW GEAR WEB
Job Number : 40405	
Estimate Number : 11768	
P.O. Number :	Part Number : D26541
This Issue : 09/07/2008 S.O. No. :	Drawing Number : D2654 REVE1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : E1
Previous Run : 39813	Material :
Written By :	Due Date : 16/07/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLP 08.7.09</u>	
Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedureDM Est Rev:E 08-06-10 revE1 as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2600-5	Web

Batch

529985

① H 8-7-9

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654 (73.85")

2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

H 8-7-9

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8 08/07/09 (EC)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SL 8-7-9

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B LOW GEAR WEB

Job Number: 40405

Part Number: D26541

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D M 8-7-10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *L.B*

D M 8-7-10

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10

Job Completion



mf 08-07-10

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	






Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

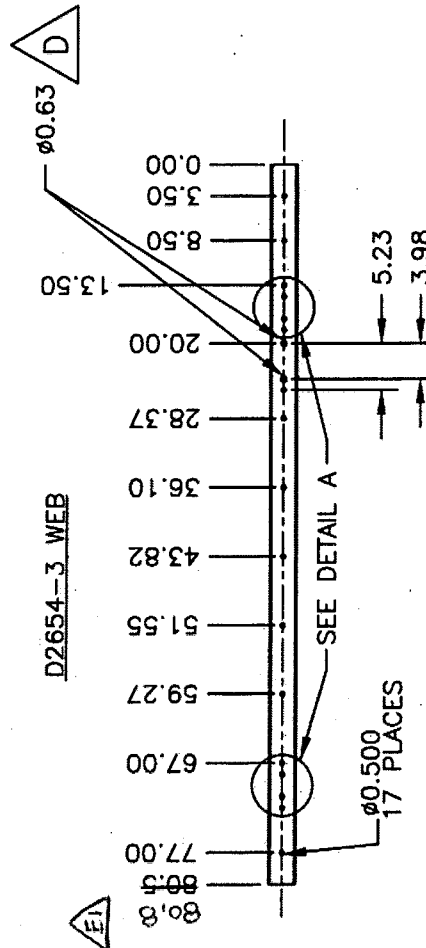
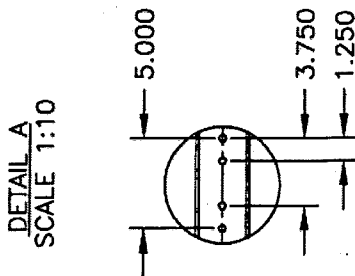
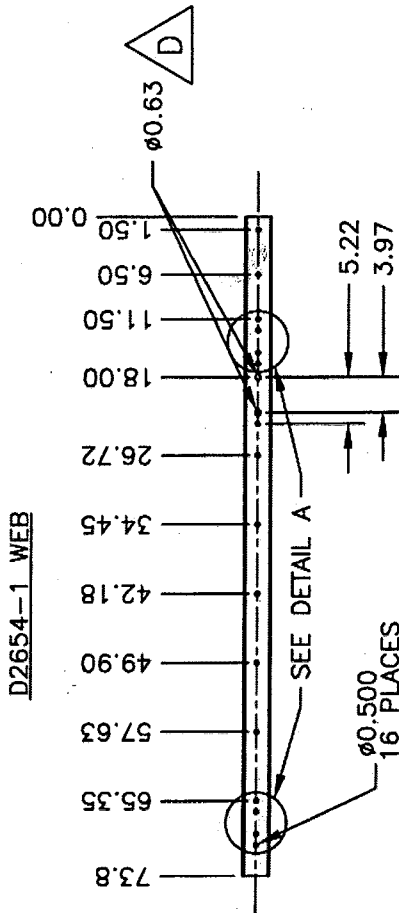
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26				TITLE WEB	SCALE 1:20
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO Ø0.63		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	 04.08.24		PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.22

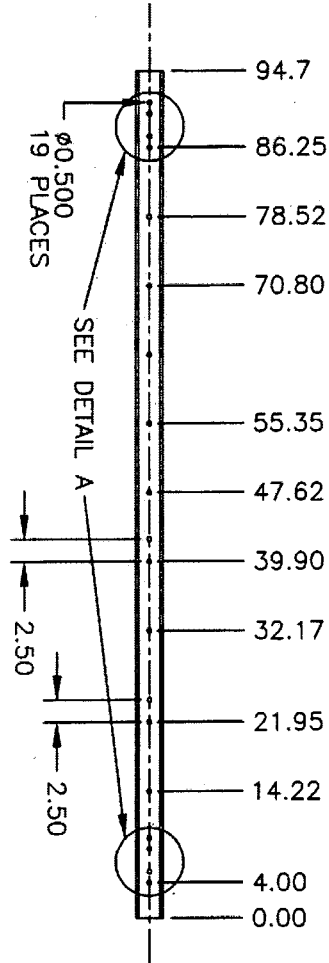
MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40405

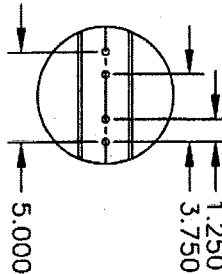
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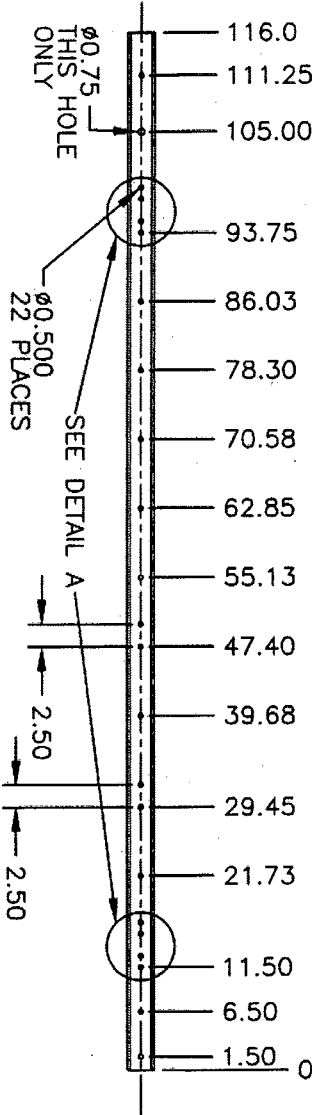
D2654-5 WEB



DETAIL A
 SCALE 1:10



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 WITHOUT NOTICE
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 NO. 40405

RELEASED
 04.05.26

DATE 04.05.26	DESIGN BY	CHECKED APPROVED	TITLE WEB
DRAWING NO. D2654	REV. E	SHEET 2 OF 2	SCALE 1:20
DART AEROSPACE USA, INC.	PORT HADLOCK, WA		